

Work Order ID 154234

154234

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Tuesday, December 06, 2016 4:20:22 PM

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Collective Lock AS350
 Start Date: 12/2/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/6/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date DEC 07 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3372	Rev B								
100	Small Fab	0.00				DEC 21 2016		DAS 6 9-89	
100									
Small Fab	Memo	0.05							
Small Fab	Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372 Identify as D3372-3								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Small Fab	0.00							
120									
Small Fab	Memo	0.02							
Small Fab	1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5								

Pickit

1 12/22/16 Cpc

1 FF DEC 22 2016

154234

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N9000401 00

Setup Start *NS1*

Stop *NS2*

Start Date: 12/2/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/6/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

130

Small Fab

Small Fab

Small Fab

Memo

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty	Part Number	Description	Batch
A/R	N/A	Locktite 262	M133096

Identify as D3372-053

2-Assemble D3372-051 as per Dwg

0.00

0.02

0.00

0.01

2 FF DEC 22 2016

1 DEC 23 2016 GPC

140

140

Large Fab

Large Fab

Large Fab

Memo

Tack weld lock shaft as per Dwg D3372

A/R SS Rod Batch 136158

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Item ID: D3372-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Collective Lock AS350

Start Date: 12/2/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/6/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

1x

DAS
43
9-89

DEC 22 2016

160

0.00

160

Small Fab

Memo

0.02

Small Fab

FINISH ASSEMBLY

1

FF

DEC 22 2016

165

QC5- Inspect part completeness to step on W/O

0.00

165

QC

Memo

0.00

Quality Control

④ 17.01.06

DAS
9
9-89

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: 5499	0.00							
170									
Packaging	Memo	0.00				/			
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.02							
Quality Control									

DAS
21
9-85

JAN 1 0 2017

MF
17-1-10

Picklist Print

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Work Order ID: 154234

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Parent Item: D3372-041

D3372-041

Parent Item Name: Collective Lock AS350

Start Date: 12/2/2016

Required Date: 12/6/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
IPP Rev:B Added Key ID _____ 06.03.21 EC IPP Rev:C
added D3384-043 DD 10.05.13 verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC *5/16WC* Washer		Purchased	No			100	Each	273.0000	2	2			
									**	DEC 2 1 2016			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST583	273						
						m135850	10						
						m136279	263						
AN5-42A *AN5-42A* Bolt		Purchased	No			100	Each	6.0000	1	1			
									**	DEC 2 1 2016			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST336	6						
						m132930	6						
D2728-7 *D2728-7* Dart Logo Label		Manufactured	Yes			100	Each	0.0000	1	1			
									**				
D3369-5 *D3369-5* Spacer		Manufactured	No				Each	4.0000		1			
									**	DEC 2 1 2016			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST032	4						
						154002	4						

Picklist Print

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Parent Item: D3372-041

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Parent Item Name: Collective Lock AS350

Start Date: 12/2/2016

Required Date: 12/6/2016

Start Qty: 1.00

Required Qty: 1.00

D3372-1

Manufactured No

100 Each 4.0000 1 1

D3372-1

Main Body

**

DEC 2 1 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST499

4

148599

4

D3372-5

Manufactured No

100 Each 6.0000 1 1

D3372-5

Cam Lock Shaft

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST032

6

123362

6

D3372-7

Manufactured No

100 Each 3.0000 1 1

D3372-7

Slider Body

**

DEC 2 1 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST499

3

141172

3

D3373-1

Manufactured No

100 Each 20.0000 1 1

D3373-1

Cam Lock

**

Location

Loc Qty

Loc Code

GA

15

139798

3

147075

12

ST032

5

74862

5

DAS
6
9-89

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Parent Item: D3372-041

D3372-041

Parent Item Name: Collective Lock AS350

Start Date: 12/2/2016

Required Date: 12/6/2016

Start Qty: 1.00

Required Qty: 1.00

D3384-043 Manufactured No

100 Each 1.0000 1 1

D3384-043

Cyclic Sock Assembly

**

DEC 21 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST500

1

148600

1

HX-81 Purchased No

100 Each 24.0000 1 1

HX-81

1/4"-20 SHCS 3/8" long

**

DEC 21 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST563

24

123436

24

NAS1149F0463P Purchased No

100 Each 590.0000 2 2

NAS1149F0463P

Washer

**

DEC 21 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST262

590

m127832

590